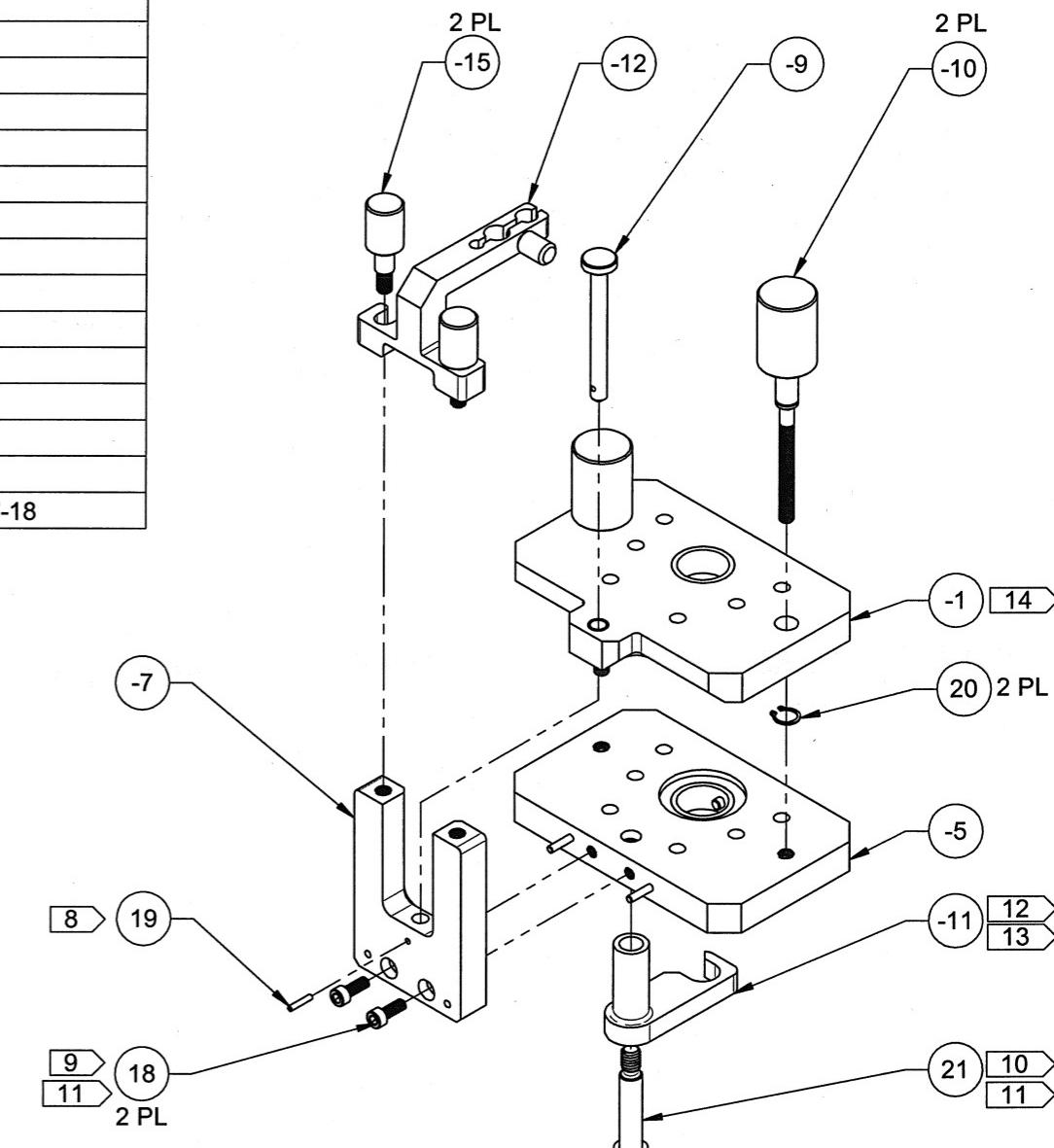
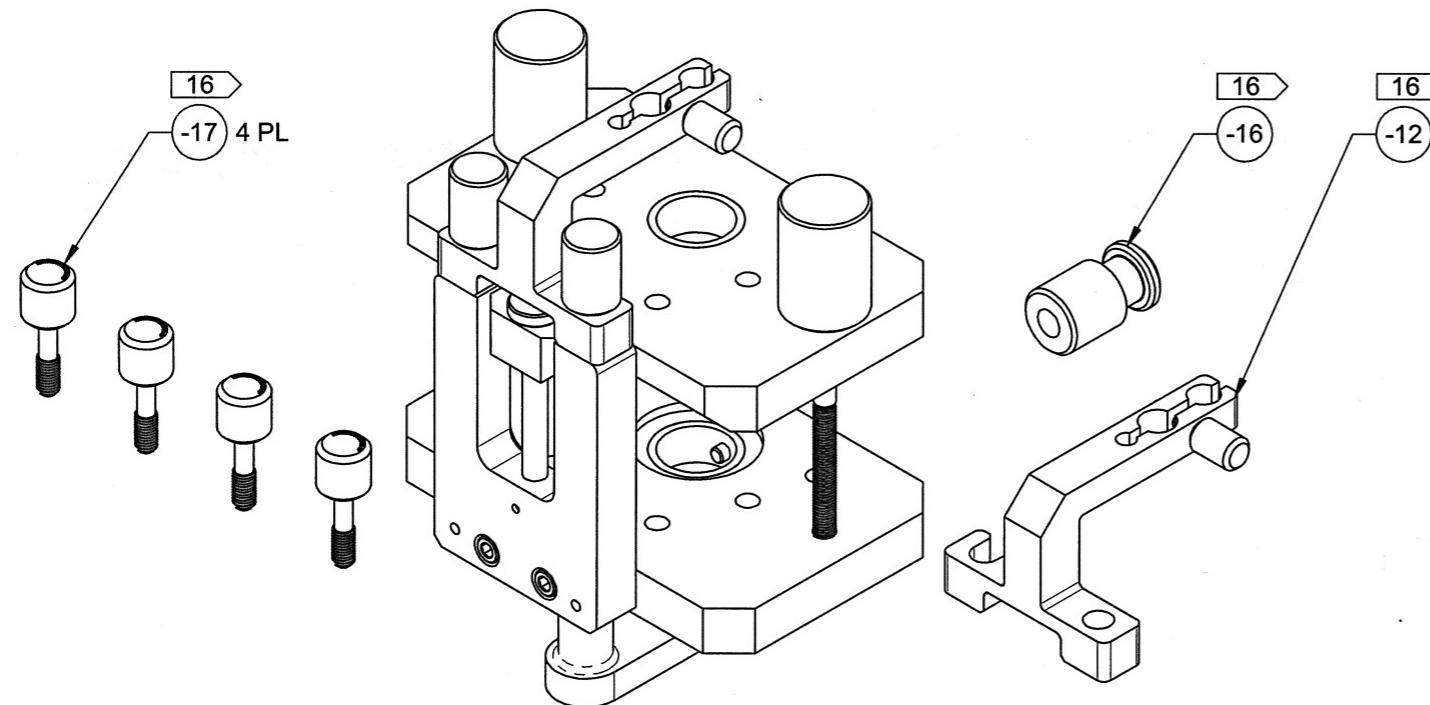


ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6000G01732-6F-1	TOP PLATE ASSY
-5	1	RBW6000G01732-6F-5	BOTTOM PLATE ASSY
-7	1	RBW6000G01732-6F-7	SIDE PLATE ASSY
-9	1	RBW6000G01732-6F-9	ALIGNMENT PIN
-10	2	RBW6000G01732-6F-10	ADJUSTABLE PIN
-11	1	RBW6000G01732-6F-11	HOOK
-12	2	RBW6000G01732-6F-12	CLAMP ASSY
-15	2	RBW6000G01732-6F-15	ROTATION CLAMP PIN
-16	1	RBW6000G01732-6F-16	SPACER
-17	4	RBW6000G01732-6F-17	HOLE PIN
18	2	NAS1351-3-8P	CAD PLATED STEEL SOCKET HEAD SCREW #10-32 X 1/2" LG.
19	1	MS16555-320	PHOSPHATE PLATED STEEL DOWEL PIN 3/32" DIA. X 1/2" LG.
20	2	MS16624-1037	CAD PLATED STEEL EXTERNAL RETAINING RING FOR 3/8" OD
21	1	MS51576-36	STEEL SHOULDER SCREW 3/8" SHOULDER DIA. X 1-1/2" SHOULDER LENGTH X 5/16"-18



TOOL ASSY WITHOUT SPARE PARTS

- NOTES:
 1) MATERIAL: N/A
 2) HEAT TREAT: N/A
 3) FINISH: N/A
 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 6) IDENTIFICATION: N/A
 7) ASSEMBLE AS SHOWN
 8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
 THEN PRESS FIT ITEM 19 WITH ITEM -9, AND REMOVE EXCESS
 9) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 18 THEN ASSEMBLE WITH ITEM -5, AND REMOVE EXCESS
 10) APPLY RED THREADLOCKER LOCTITE 263/262 ON THREADS OF ITEM 21 THEN ASSEMBLE WITH ITEM -5, AND REMOVE EXCESS
 11) INSTALL ITEM 18 AND ITEM 21 HAND TIGHT
 12) ITEM -11 MUST ROTATE FREELY
 13) ITEM -11 MUST BE CONCENTRIC WITH ITEM -5, ITEM -1 AND ITEM -12 HOLES WHEN ENGAGED
 14) ITEM -1 MUST SLIDE FREELY INTO ITEM -7
 15) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG
 16) SPARE PARTS MUST BE PACKAGED INDIVIDUALLY WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

A	NEW ISSUE	19-862	VM
REV.	DESCRIPTION	ECN #	BY
DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	
MFG. APPR.	FK	RBW6000G01732-6F	
APPROVED	(initials)	TITLE	
DATE 2019-08-16		SCALE NTS	
COPRIGHT © 2019 BY DART AEROSPACE LTD			
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8

7

6

5

4

3

2

1

D

D

C

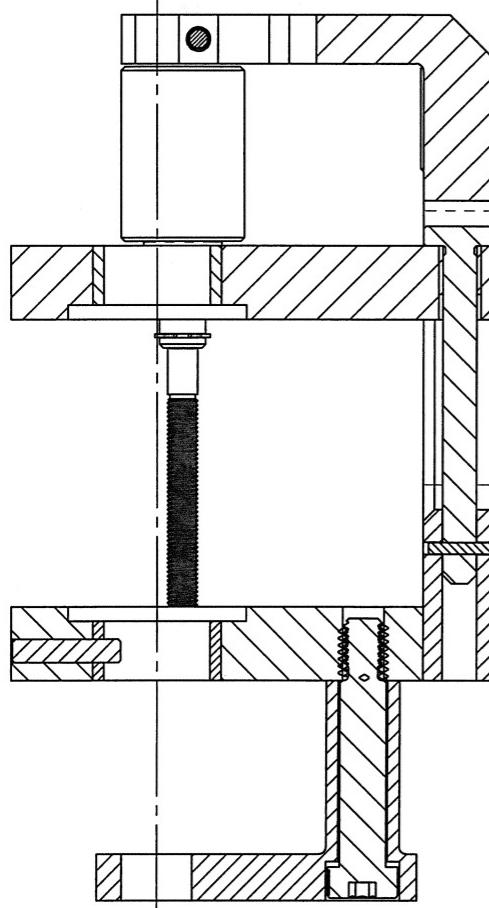
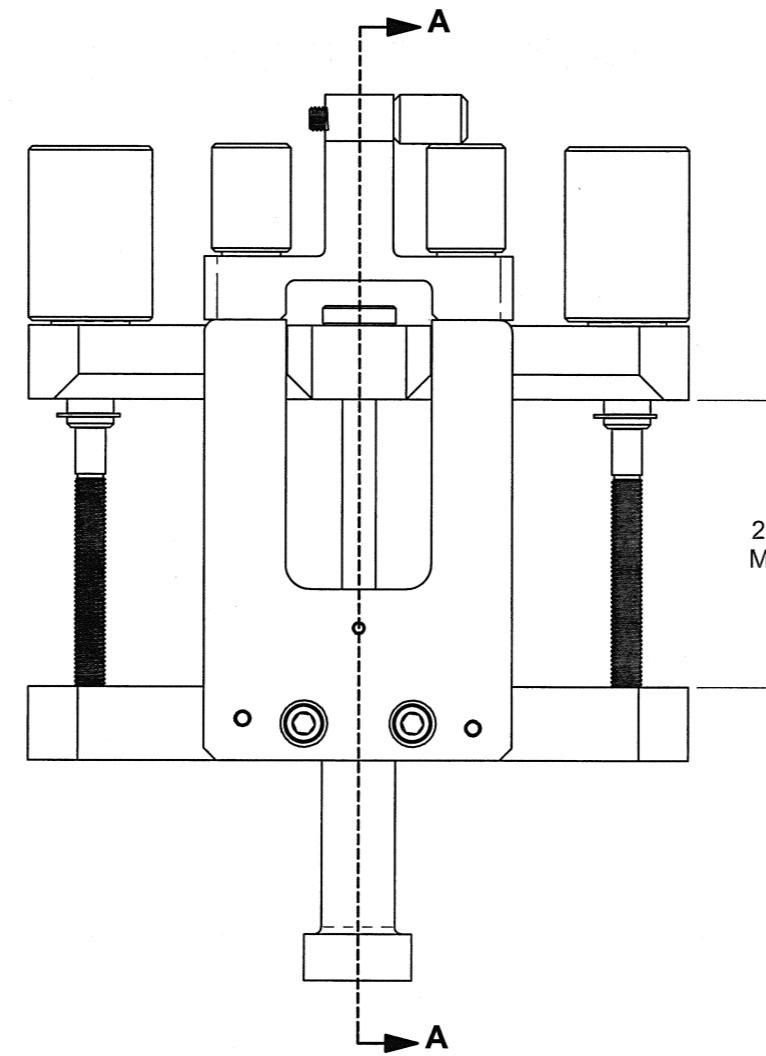
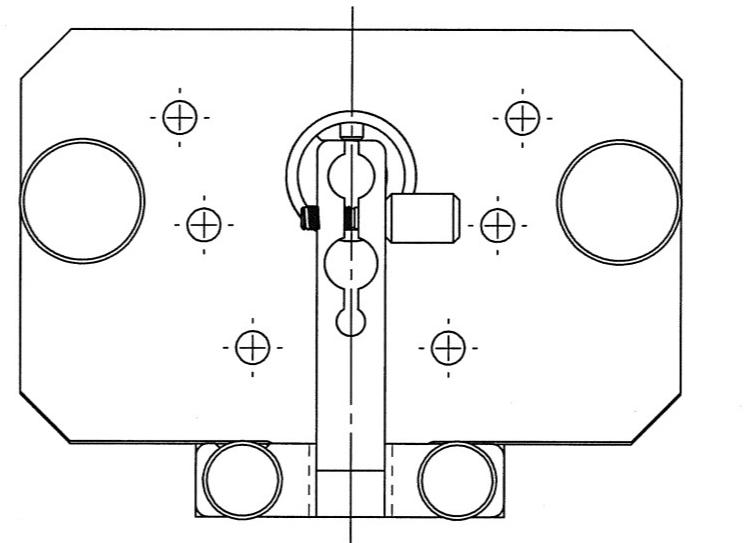
C

B

B

A

A

**SECTION A-A**

DESIGN	VM
DRAWN	VM
CHECKED	KPT
MFG. APPR.	FK
APPROVED	<i>[Signature]</i>

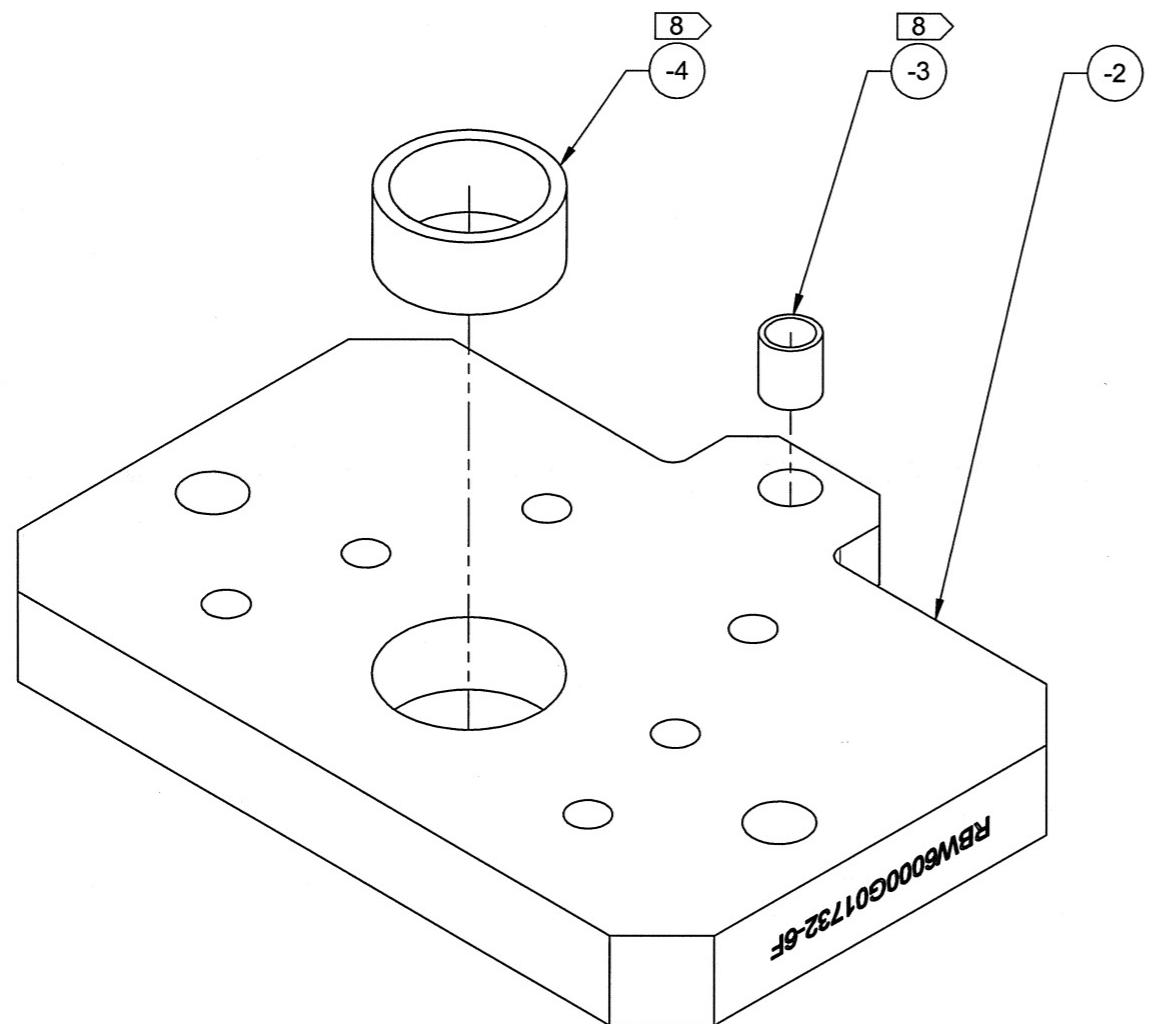
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

TOOL PART #	REV. A
RBW6000G01732-6F	
SHEET 2 OF 19	
TITLE	
AXIAL PLAY CHECK TOOL	
DATE 2019-08-16	
SCALE NTS	

COPYRIGHT © 2019 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

ITEM #	QTY	PART #	PART TITLE
-2	1	RBW6000G01732-6F-2	TOP PLATE
-3	1	RBW6000G01732-6F-3	PIN BUSHING
-4	1	RBW6000G01732-6F-4	ALIGNMENT BUSHING

D

**RBW6000G01732-6F-1 TOP PLATE ASSY****NOTES:**

1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°

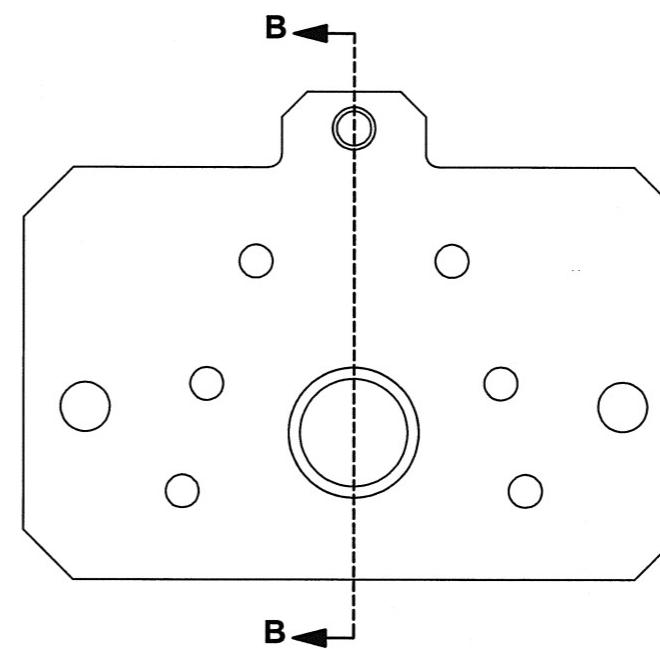
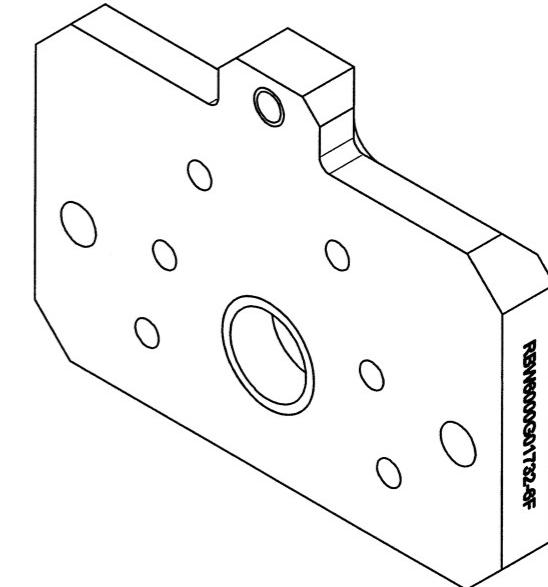
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

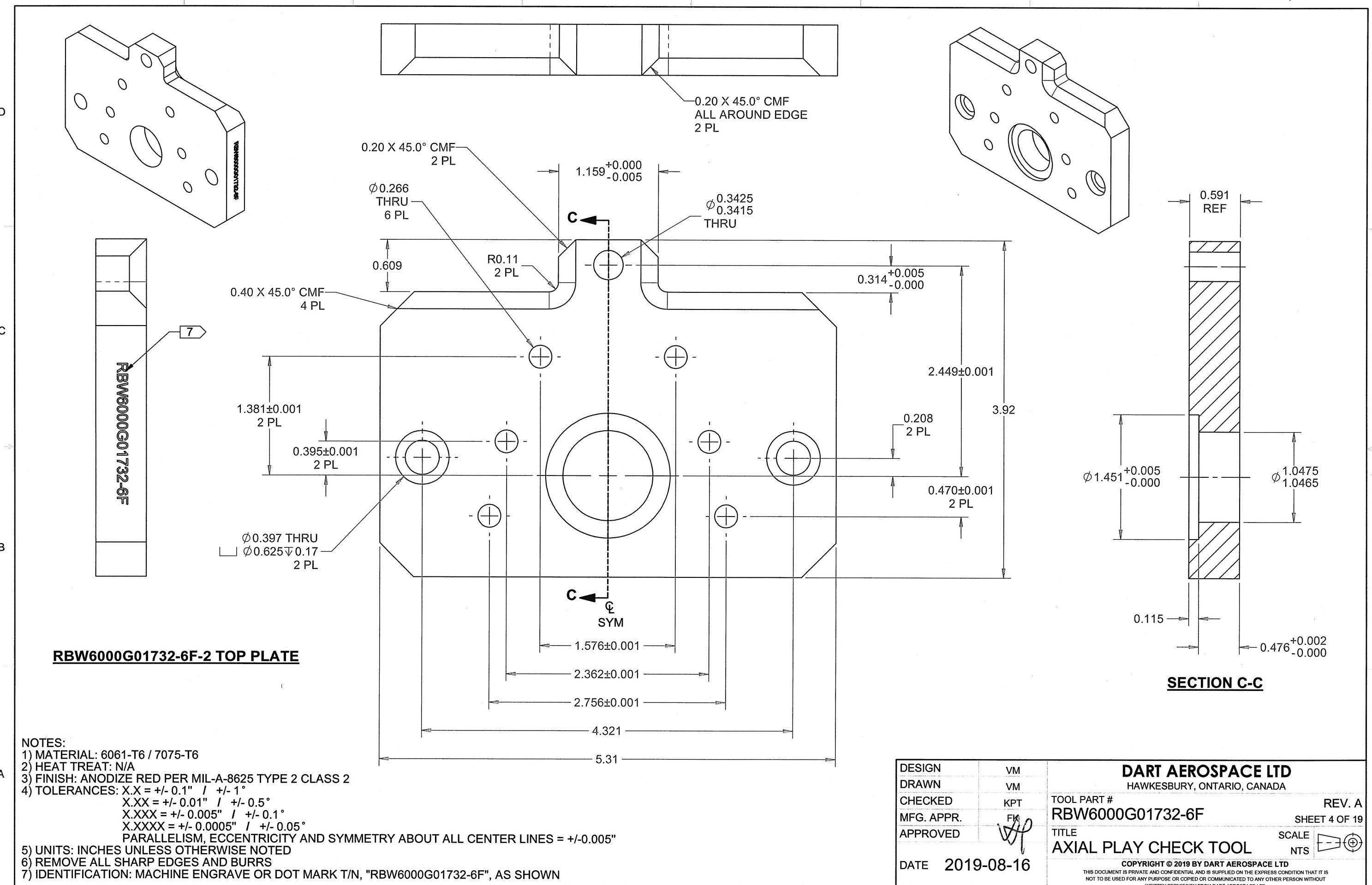
6) IDENTIFICATION: N/A

7) ASSEMBLE AS SHOWN

8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM -3 AND ITEM -4 FLUSH TO SURFACE OF ITEM -2 AS SHOWN, AND REMOVE EXCESS

**SECTION B-B**

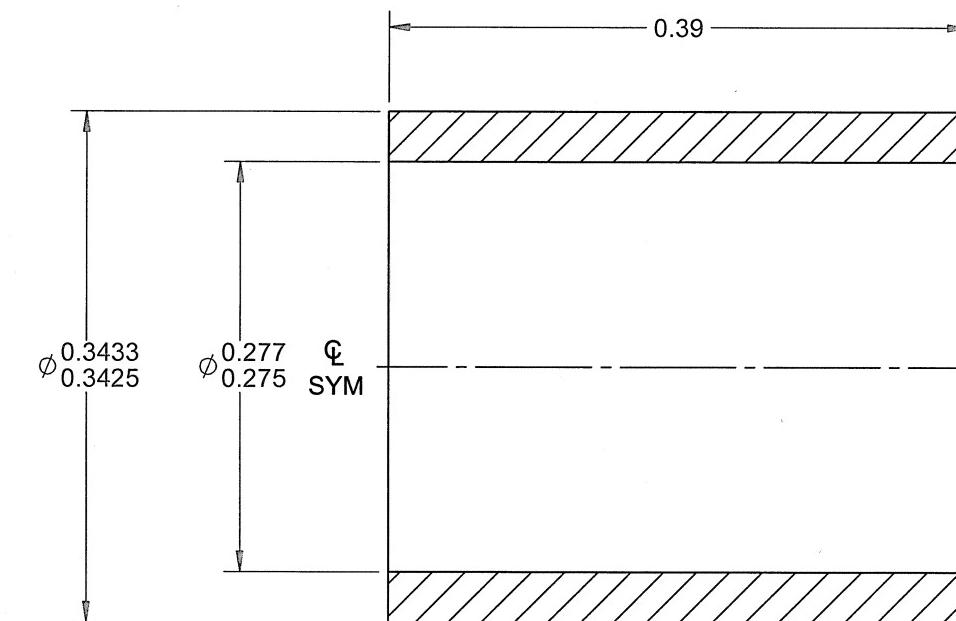
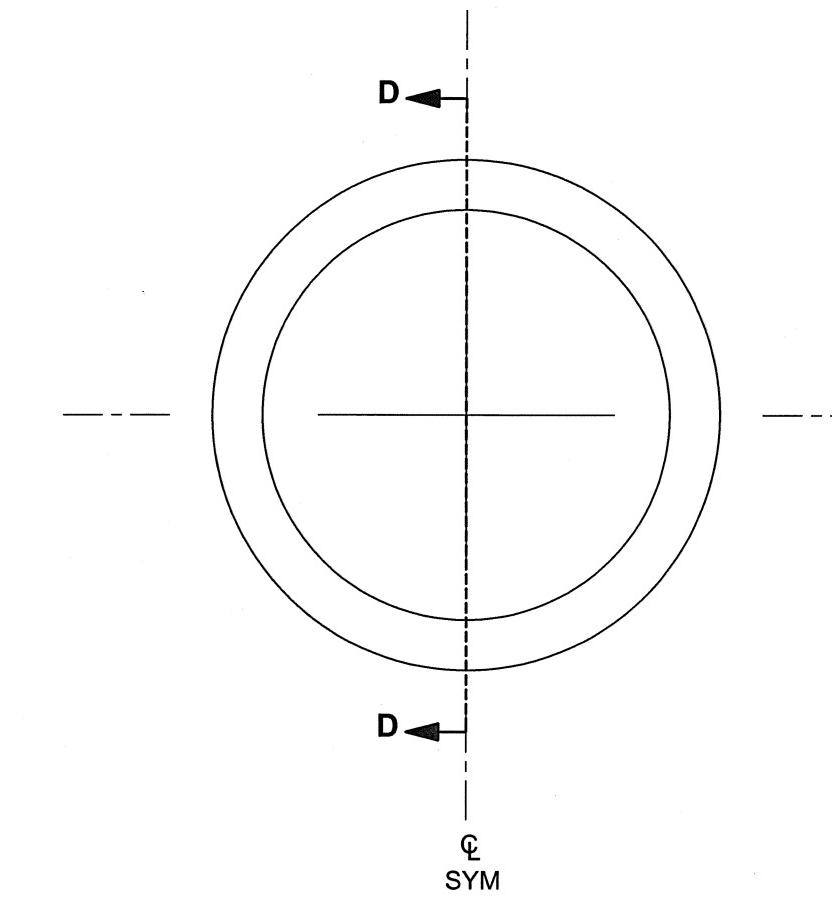
DESIGN DRAWN	VM VM	DART AEROSPACE LTD
CHECKED	KPT	HAWKESBURY, ONTARIO, CANADA
MFG. APPR.	FK	REV. A
APPROVED	WP	TOOL PART #
		RBW6000G01732-6F
		TITLE
		AXIAL PLAY CHECK TOOL
DATE 2019-08-16		SCALE NTS
COPRIGHT © 2019 BY DART AEROSPACE LTD		
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		



8 7 6 5 4 3 2 1

D

D

**SECTION D-D****RBW6000G01732-6F-3 PIN BUSHING****NOTES:**

- 1) MATERIAL: BRONZE C63000
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

A

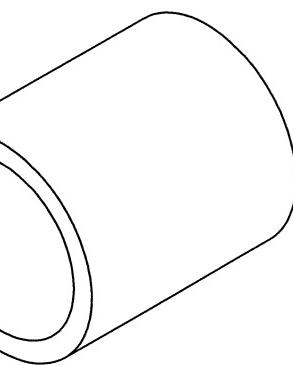
A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6000G01732-6F	SHEET 5 OF 19
APPROVED	WP	TITLE	AXIAL PLAY CHECK TOOL
		SCALE	NTS

DATE 2019-08-16

COPYRIGHT © 2019 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8 7 6 5 4 3 2 1



D

C

B

A

1

8

7

6

5

4

3

2

1

D

D

C

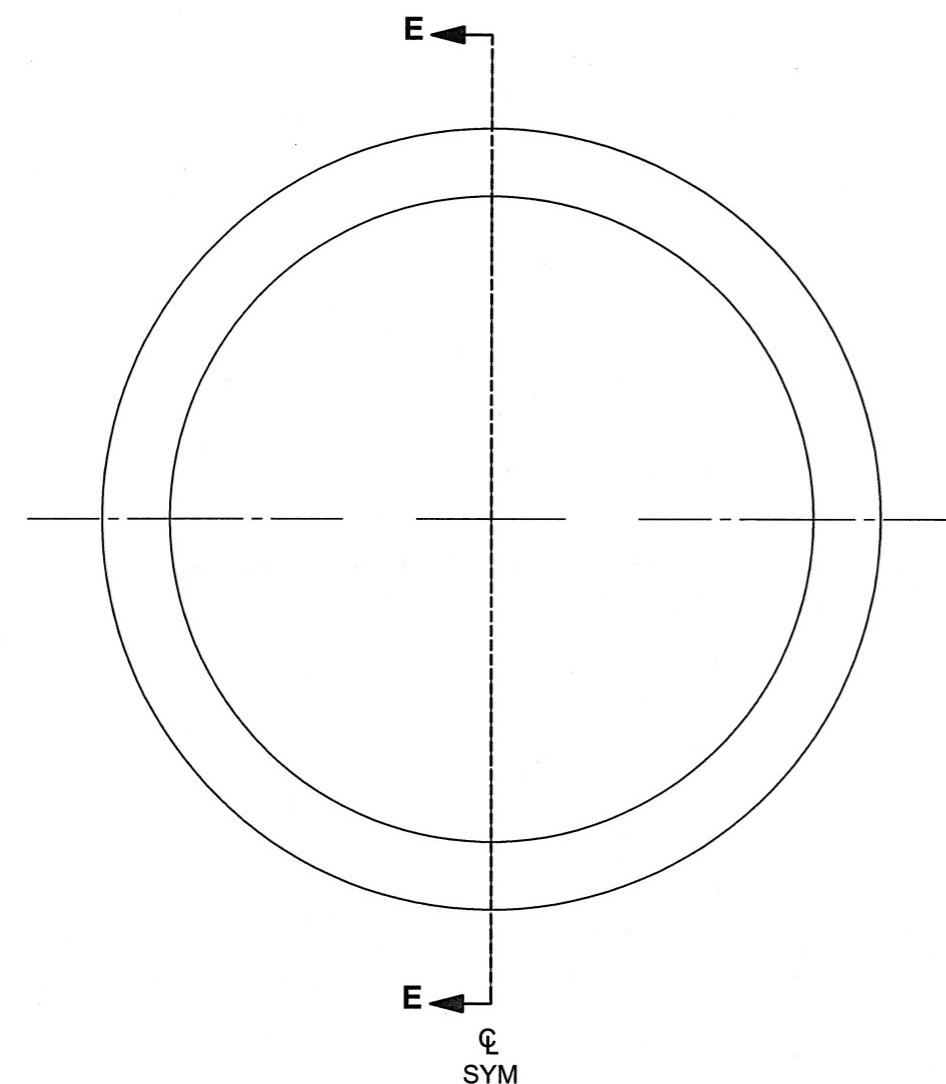
C

B

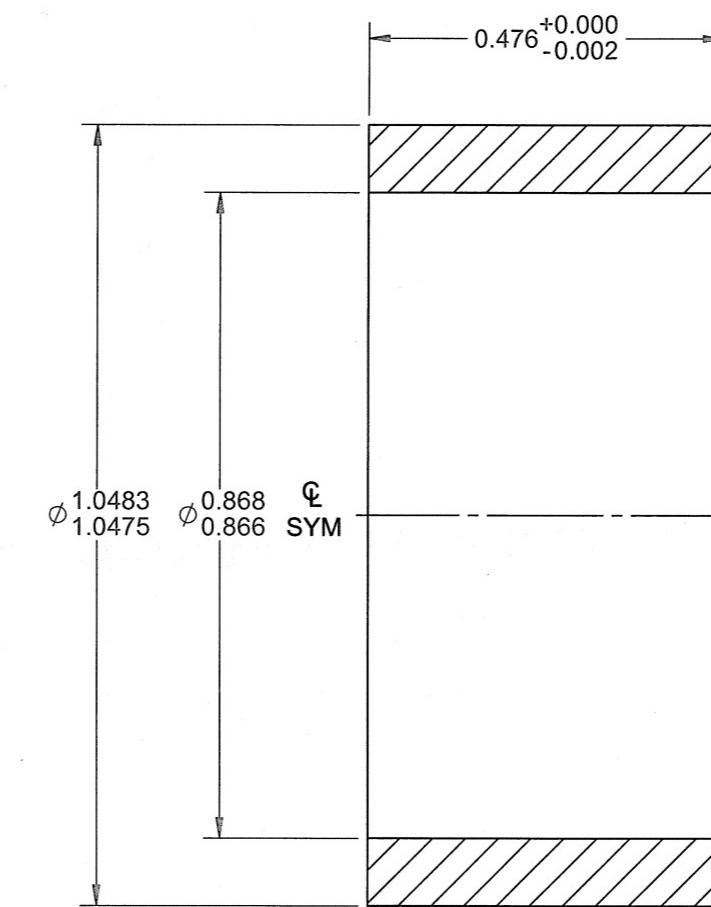
B

A

A



RBW6000G01732-6F-4 ALIGNMENT BUSHING



SECTION E-E

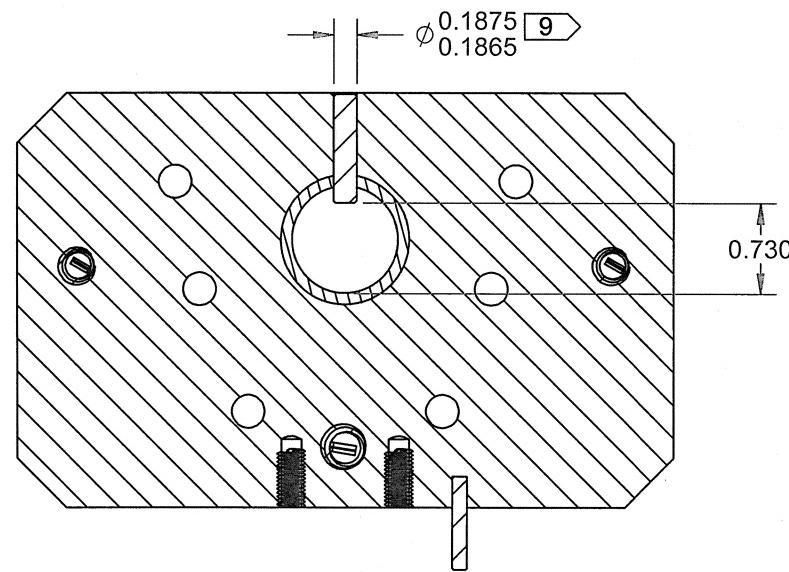
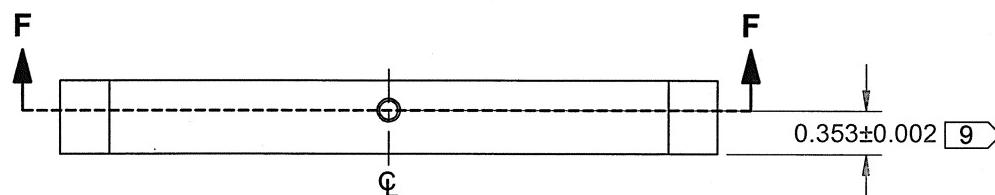
NOTES:

- 1) MATERIAL: BRONZE C63000
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6000G01732-6F	SHEET 6 OF 19
APPROVED	<i>[Signature]</i>	TITLE	AXIAL PLAY CHECK TOOL
DATE 2019-08-16		SCALE NTS	

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

ITEM #	QTY	PART #	PART TITLE
-4	1	RBW6000G01732-6F-4	ALIGNMENT BUSHING
-6	1	RBW6000G01732-6F-6	BOTTOM PLATE
22	1	MS16555-342	PHOSPHATE COATED STEEL DOWEL PIN 3/16" DIA. X 7/8" LG.
23	2	MS16555-329	PHOSPHATE COATED STEEL DOWEL PIN 1/8" DIA. X 3/4" LG.
24	2	MS21209-F4-20P	CAD PLATE SS HELICAL INSERT 1/4"-28 X 1/2" LG.
25	1	MS21209-C51-5P	CAD PLATED SS HELICAL INSERT 5/16"-18 X 0.469" LG.
26	2	MS21209-F1-25P	CAD PLATE SS HELICAL INSERT #10-32 X 0.475" LG.



SECTION F-F

RBW6000G01732-6F-5 BOTTOM PLATE ASSY

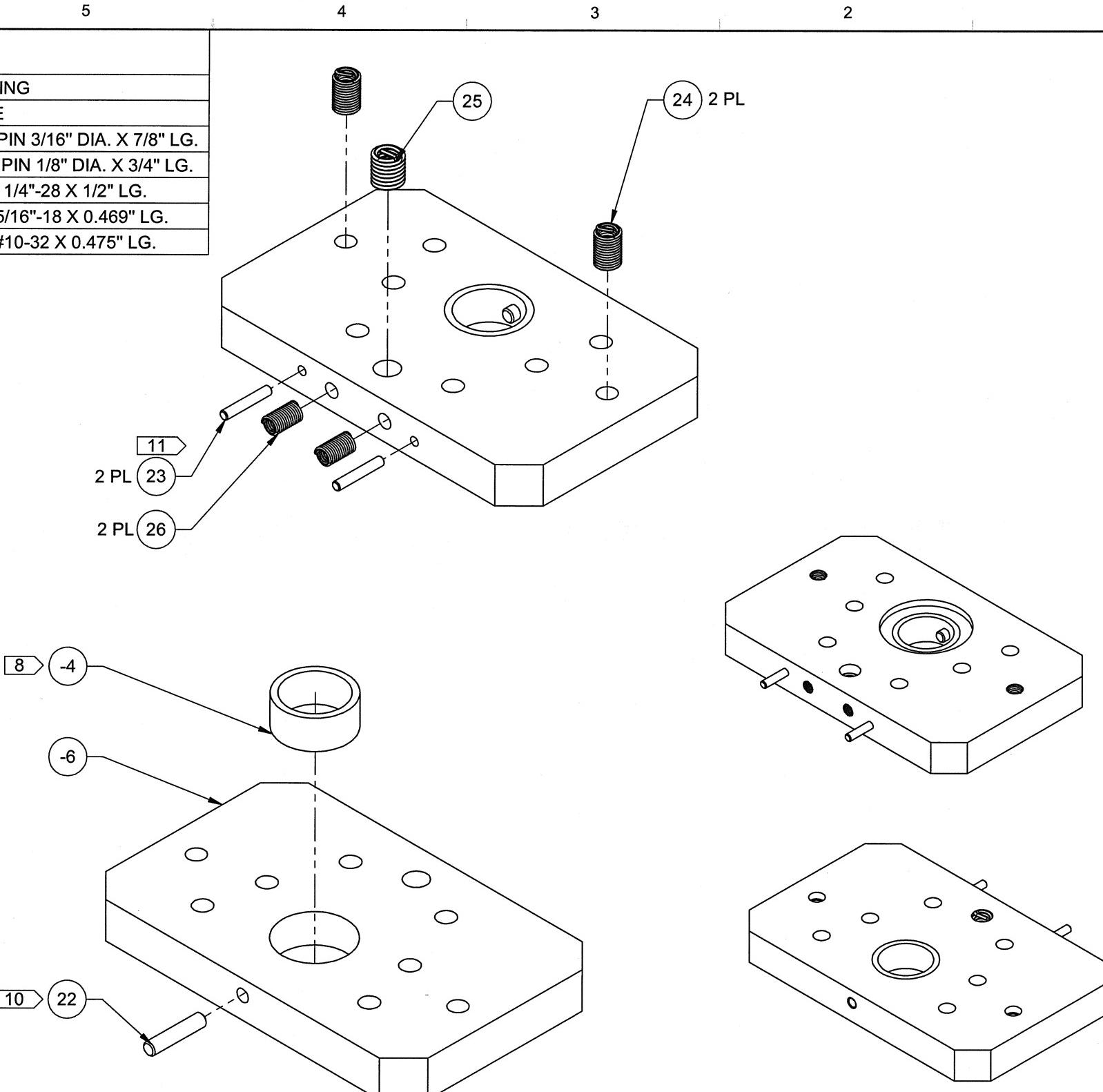
NOTES:

1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

- A
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A
7) ASSEMBLE AS SHOWN
8) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM -4 WITH ITEM -6, AND REMOVE EXCESS
9) TRANSFER DRILL HOLE THROUGH ITEMS -6 AND -4 AS SHOWN
10) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM 22 WITH ITEM -6, AND REMOVE EXCESS
11) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES
THEN PRESS FIT ITEM 23 WITH ITEM -6, AND REMOVE EXCESS



DESIGN DRAWN	VM	DART AEROSPACE LTD	
CHECKED	VM	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	KPT	REV. A	
APPROVED	FK	TOOL PART #	
		RBW6000G01732-6F	
		TITLE	
		AXIAL PLAY CHECK TOOL	
DATE 2019-08-16			

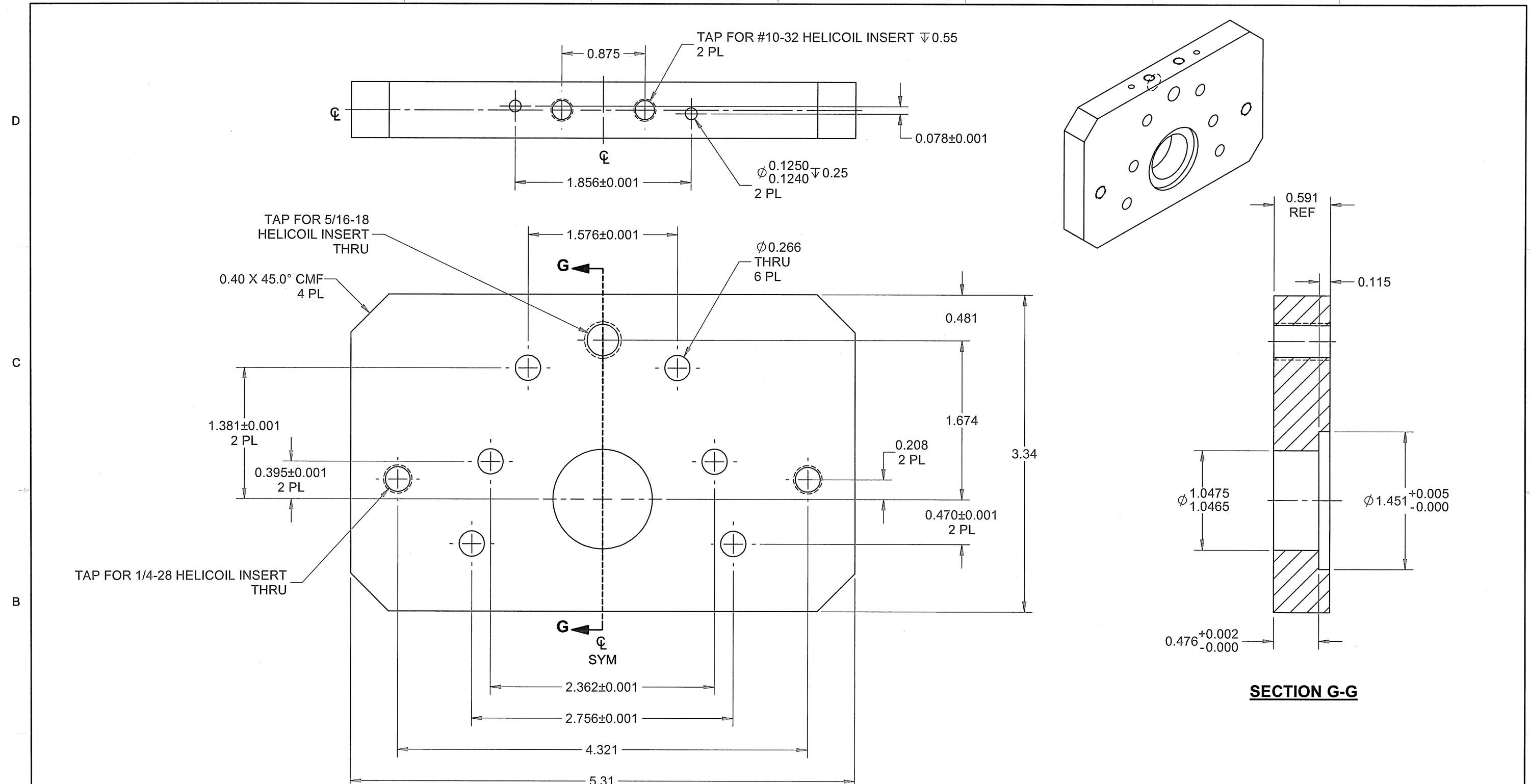
COPYRIGHT © 2019 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

SHEET 7 OF 19

SCALE NTS

2

1



NOTES:

- RBW00000001752-01 - BOTTOM**

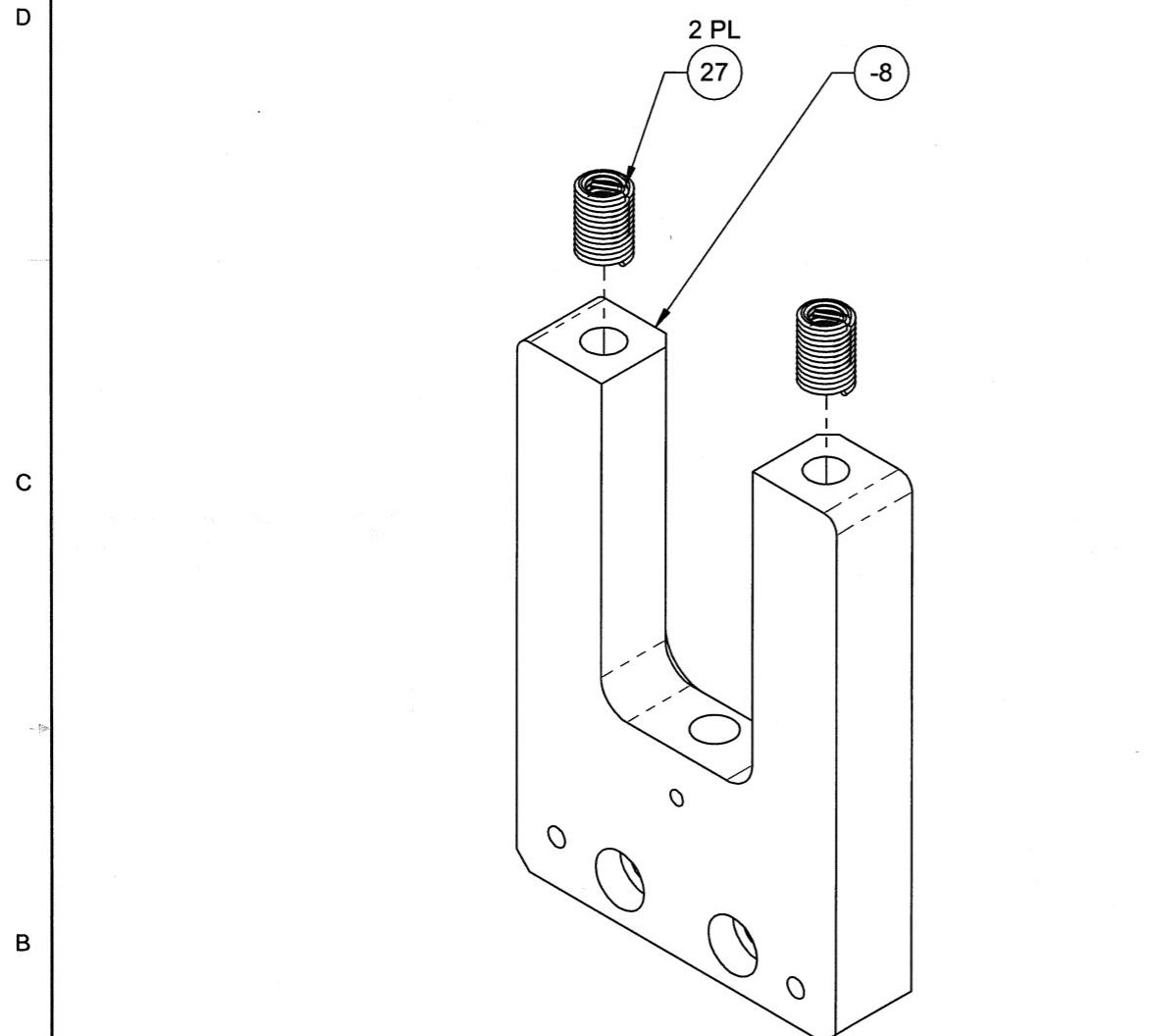
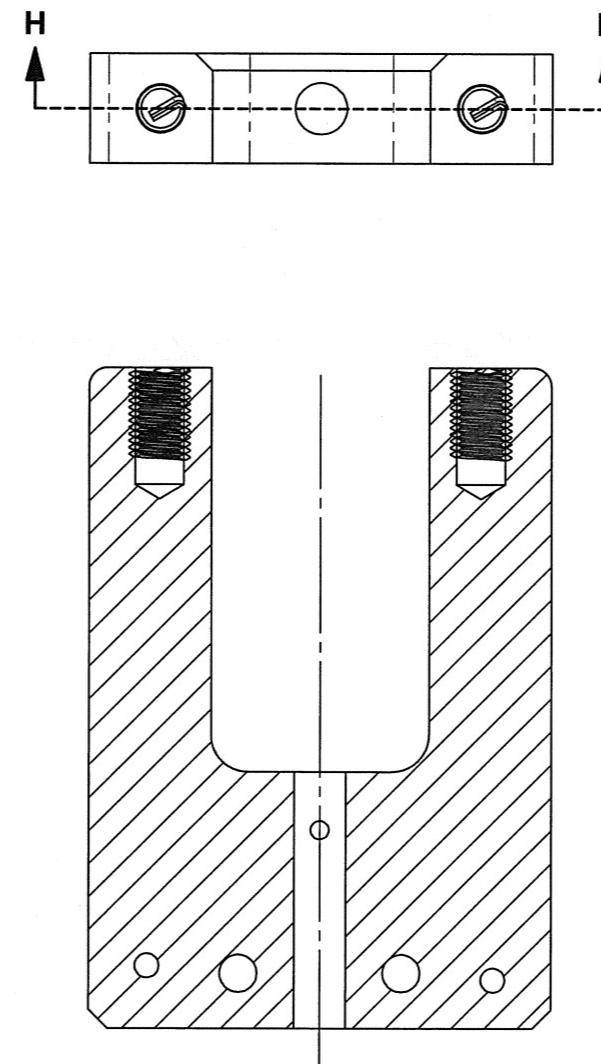
 - 1) MATERIAL: 6061-T6 / 7075-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

RBW6000G01732-6F-6 BOTTOM PLATE

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART # RBW6000G01732-6F	REV. A
MFG. APPR.	FK		SHEET 8 OF 19
APPROVED	<i>WP</i>	TITLE AXIAL PLAY CHECK TOOL	SCALE NTS 
DATE	2019-08-16	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

8 7 6 5 4 3 2 1

ITEM #	QTY	PART #	PART TITLE
-8	1	RBW6000G01732-6F-8	SIDE PLATE
27	2	MS21209-F4-20P	CAD PLATE SS HELICAL INSERT 1/4"-28 X 1/2" LG.

**RBW6000G01732-6F-7 SIDE PLATE ASSY**

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN

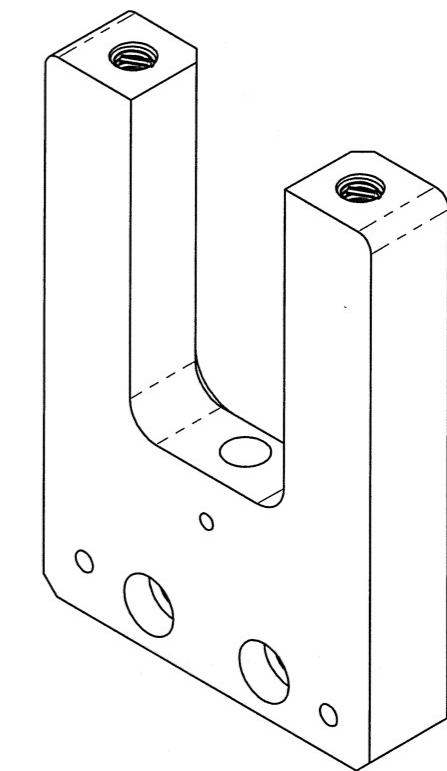
DESIGN	VM	DART AEROSPACE LTD
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	FK	RBW6000G01732-6F
APPROVED	WP	REV. A

DATE 2019-08-16

SCALE NTS

COPYRIGHT © 2019 BY DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



8

7

6

5

4

3

2

1

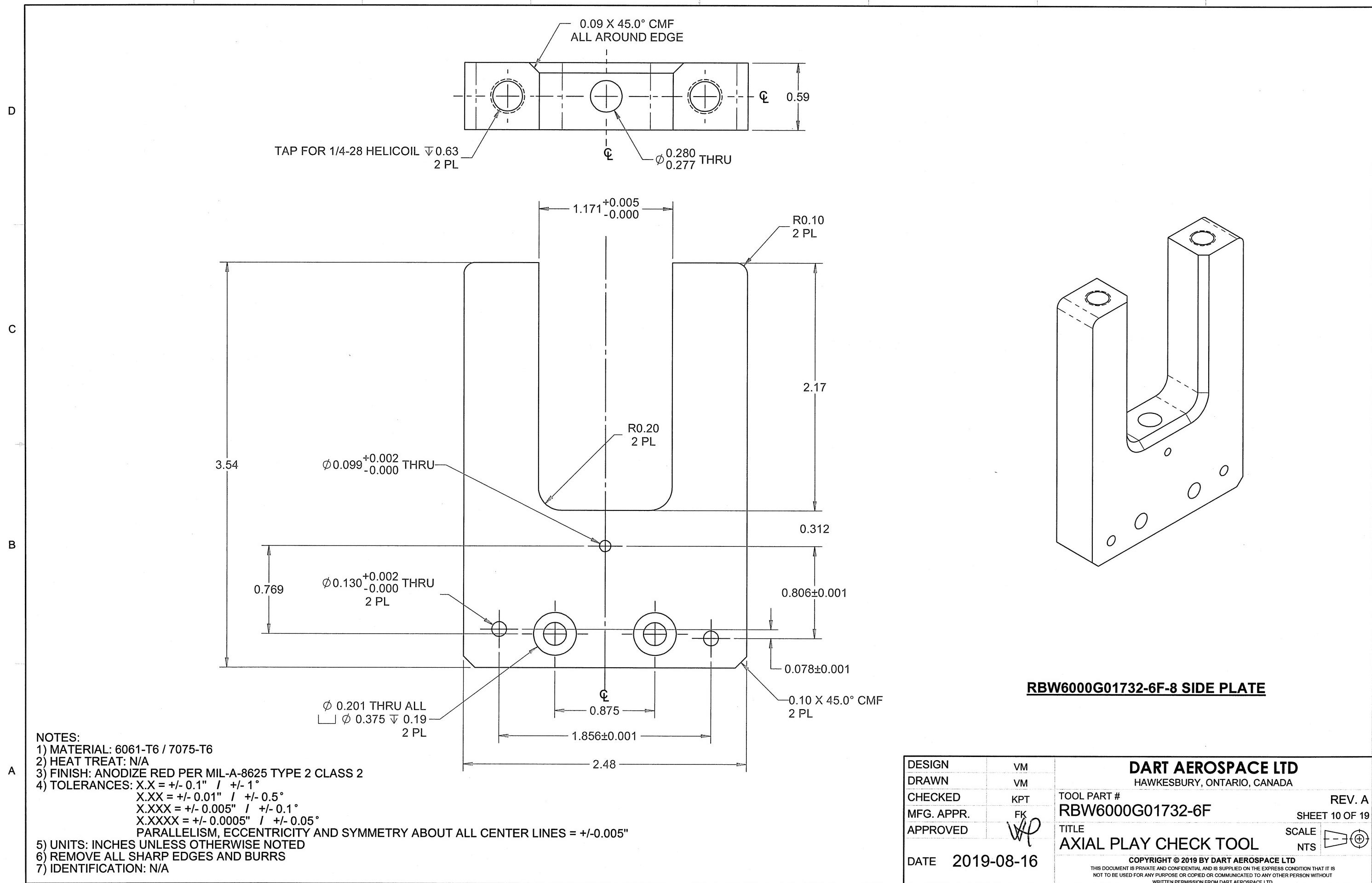
A

D

C

B

A



DESIGN DRAWN	VM VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	FK	RBW6000G01732-6F
APPROVED	WP	REV. A
DATE 2019-08-16		SHEET 10 OF 19
TITLE AXIAL PLAY CHECK TOOL		SCALE NTS

COPYRIGHT © 2019 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8

7

6

5

4

3

2

1

D

D

C

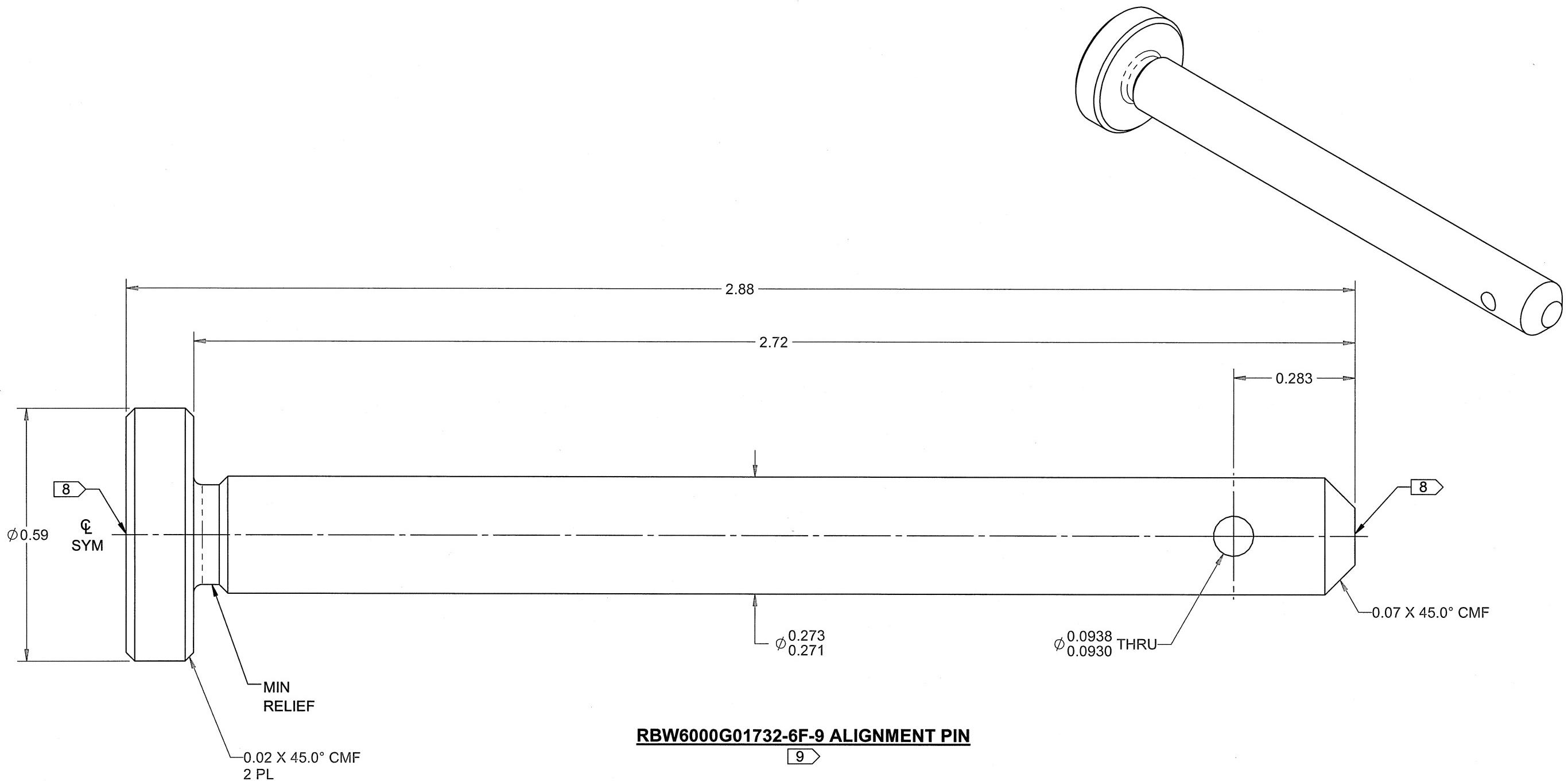
C

B

B

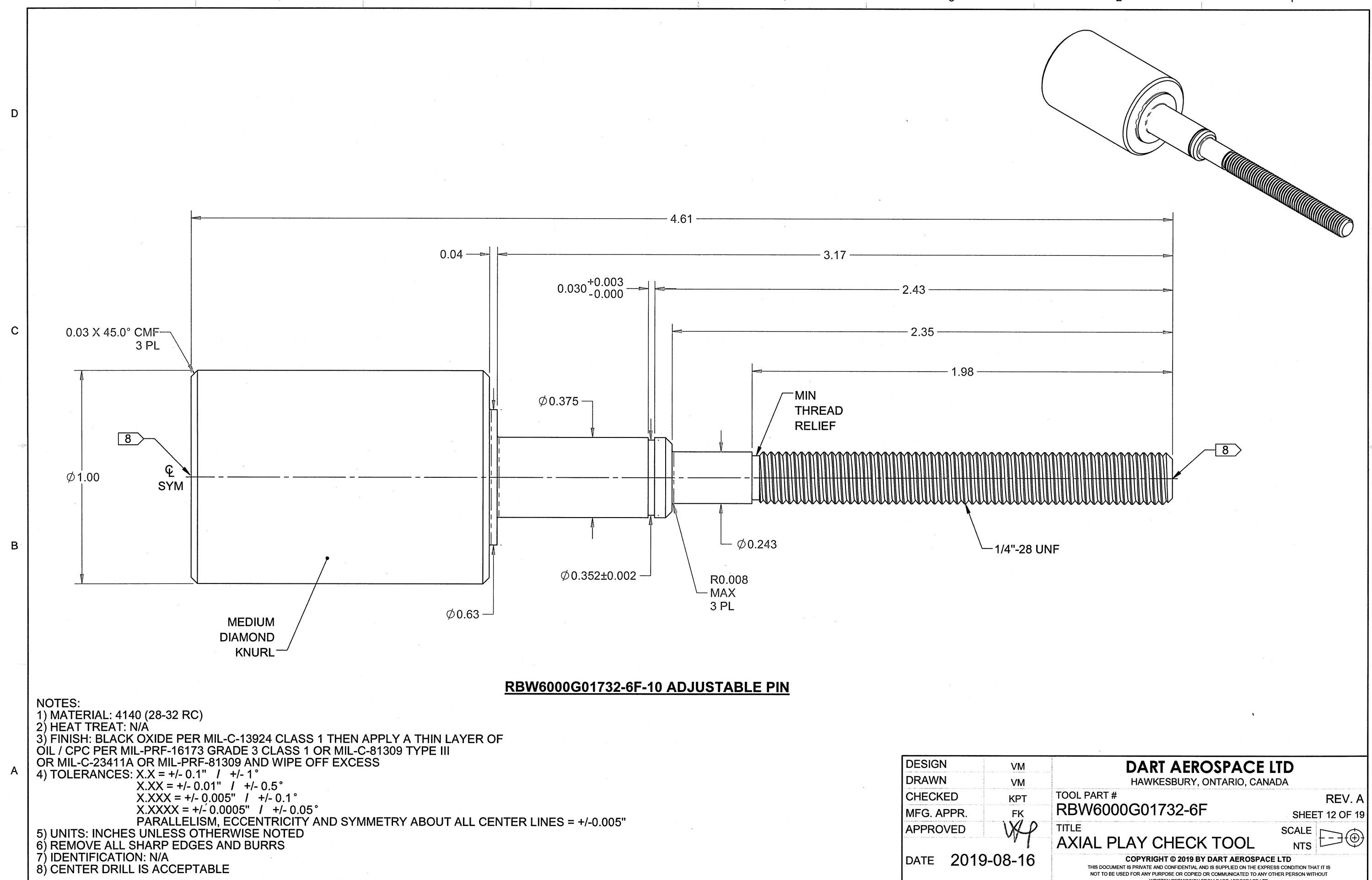
A

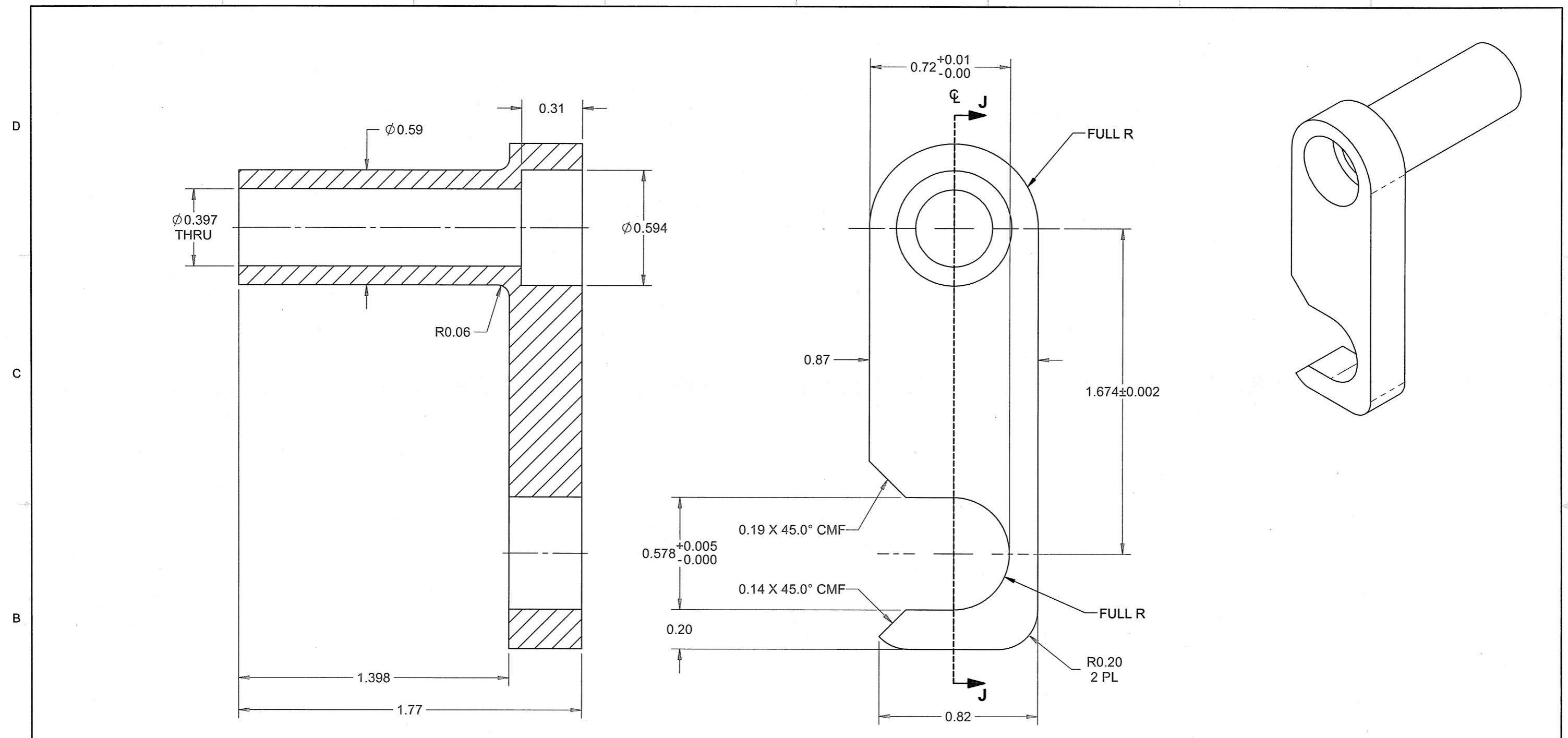
A

**NOTES:**

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE
- 9) DIMENSIONS MUST BE MET AFTER PLATING

DESIGN	VM	DART AEROSPACE LTD
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	
MFG. APPR.	FK	
APPROVED	WF	
DATE 2019-08-16		REV. A
TOOL PART # RBW6000G01732-6F		SHEET 11 OF 19
TITLE AXIAL PLAY CHECK TOOL		SCALE NTS
COPRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		



SECTION J-JRBW6000G01732-6F-11 HOOK

8

NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: ZINC PLATE (YELLOW OR BLACK) PER ASTM B633 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) DIMENSIONS MUST BE MET AFTER PLATING

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT	TOOL PART #	REV. A
MFG. APPR.	FK	RBW6000G01732-6F	SHEET 13 OF 19
APPROVED	WP	TITLE	AXIAL PLAY CHECK TOOL
		COPYRIGHT © 2019 BY DART AEROSPACE LTD	
		THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DATE 2019-08-16

ITEM #	QTY	PART #	PART TITLE
-13	1	RBW6000G01732-6F-13	CLAMP
-14	1	RBW6000G01732-6F-14	CLAMP PIN

D

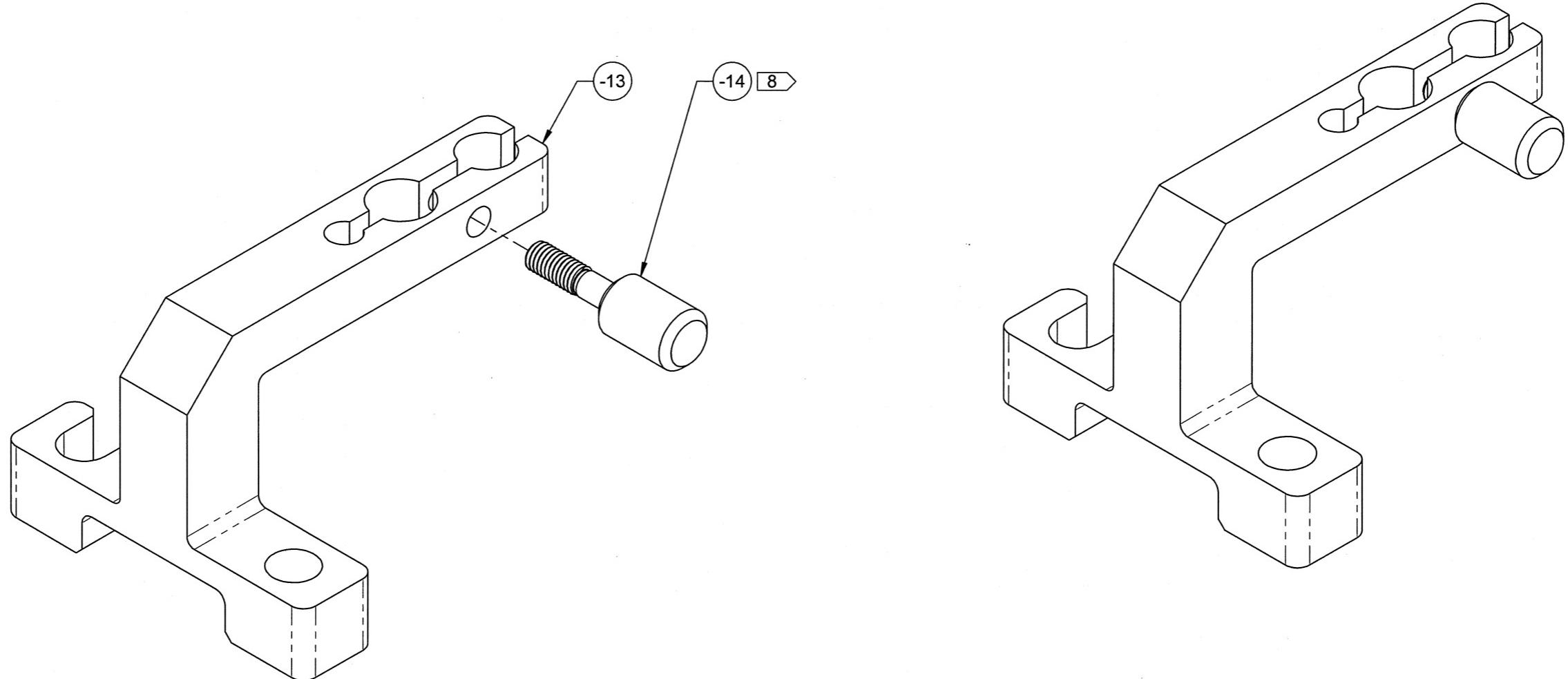
D

C

C

B

B



RBW6000G01732-6F-12 CLAMP ASSY

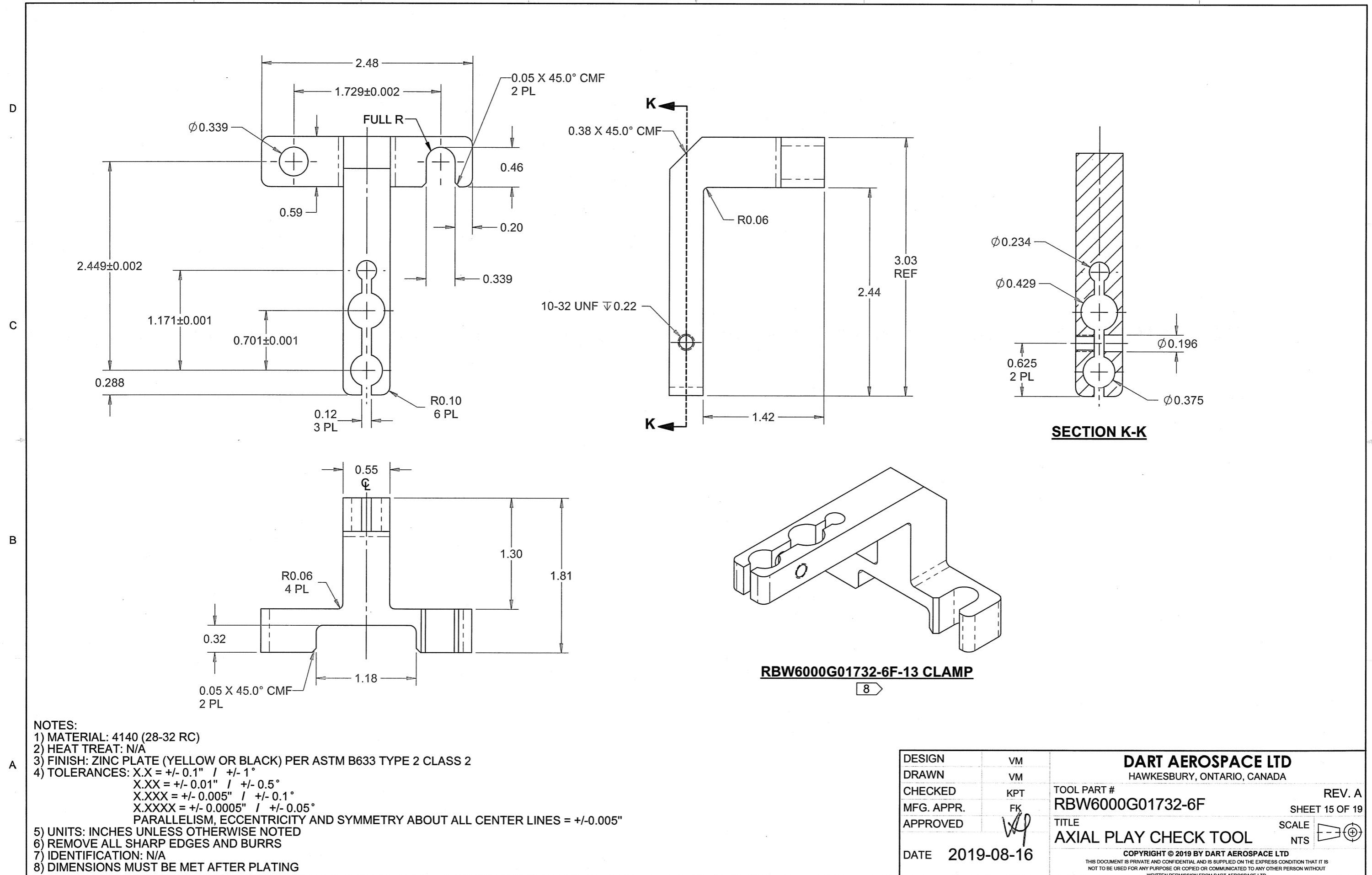
NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) INSTALL ITEM -14 HAND TIGHT

DESIGN DRAWN	VM VM	DART AEROSPACE LTD	
CHECKED	KPT	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	FK	TOOL PART #	REV. A
APPROVED	VJ	RBW6000G01732-6F	SHEET 14 OF 19
DATE 2019-08-16		TITLE	SCALE
		AXIAL PLAY CHECK TOOL	NTS

COPYRIGHT © 2019 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8 7 6 5 4 3 2 1



DESIGN	VM	DART AEROSPACE LTD
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	
MFG. APPR.	FK	
APPROVED	WJ	
DATE	2019-08-16	
TOOL PART #	RBW6000G01732-6F	REV. A
TITLE	AXIAL PLAY CHECK TOOL	SHEET 15 OF 19
SCALE	NTS	(+/-)

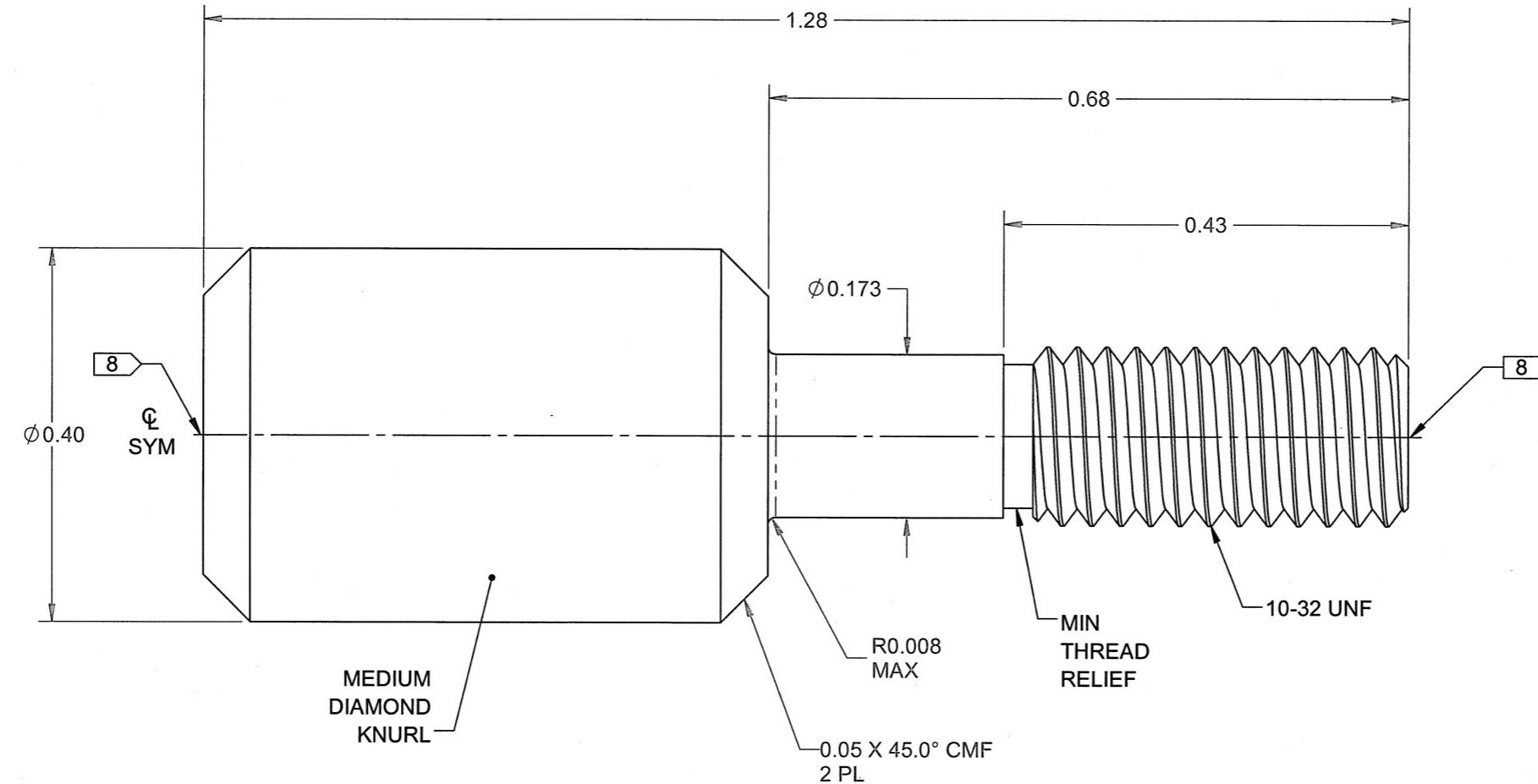
COPYRIGHT © 2019 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1

D

D



RBW6000G01732-6F-14 CLAMP PIN

NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

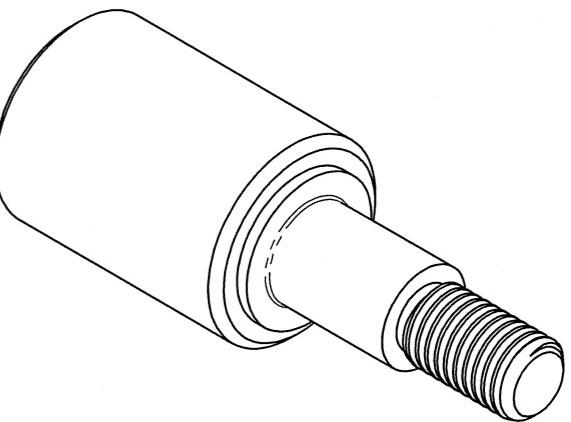
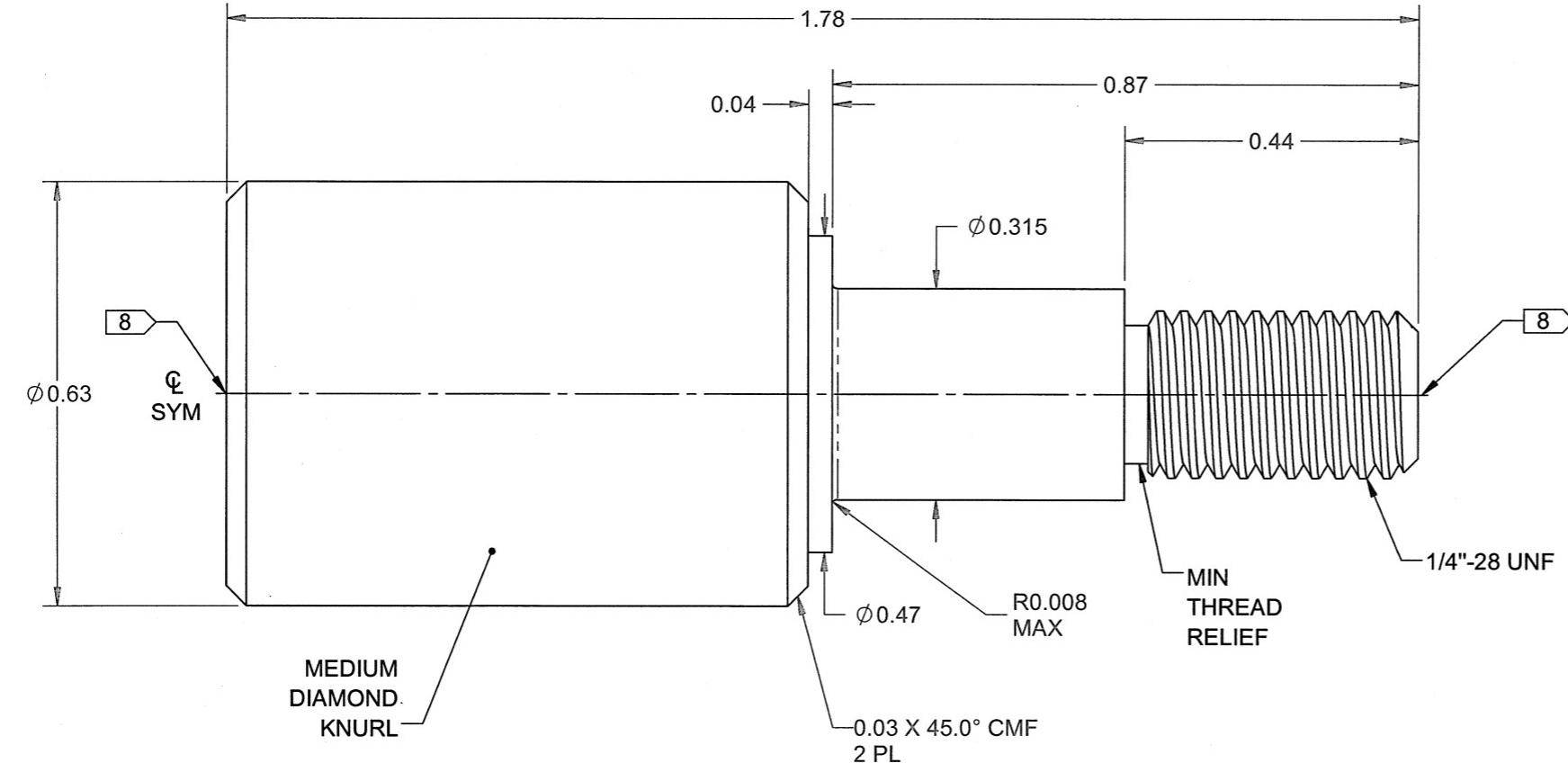
DESIGN DRAWN	VM VM	DART AEROSPACE LTD	
CHECKED	KPT	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	FK	TOOL PART #	REV. A
APPROVED	VJ	RBW6000G01732-6F	SHEET 16 OF 19
DATE 2019-08-16		TITLE AXIAL PLAY CHECK TOOL	SCALE NTS

COPYRIGHT © 2019 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8 7 6 5 4 3 2 1

D

D



C

C

B

B

RBW6000G01732-6F-15 ROTATION CLAMP PIN

NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN DRAWN	VM VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	FK	RBW6000G01732-6F
APPROVED	X	REV. A SHEET 17 OF 19
		TITLE AXIAL PLAY CHECK TOOL
		SCALE NTS
		COPYRIGHT © 2019 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

8

7

6

5

4

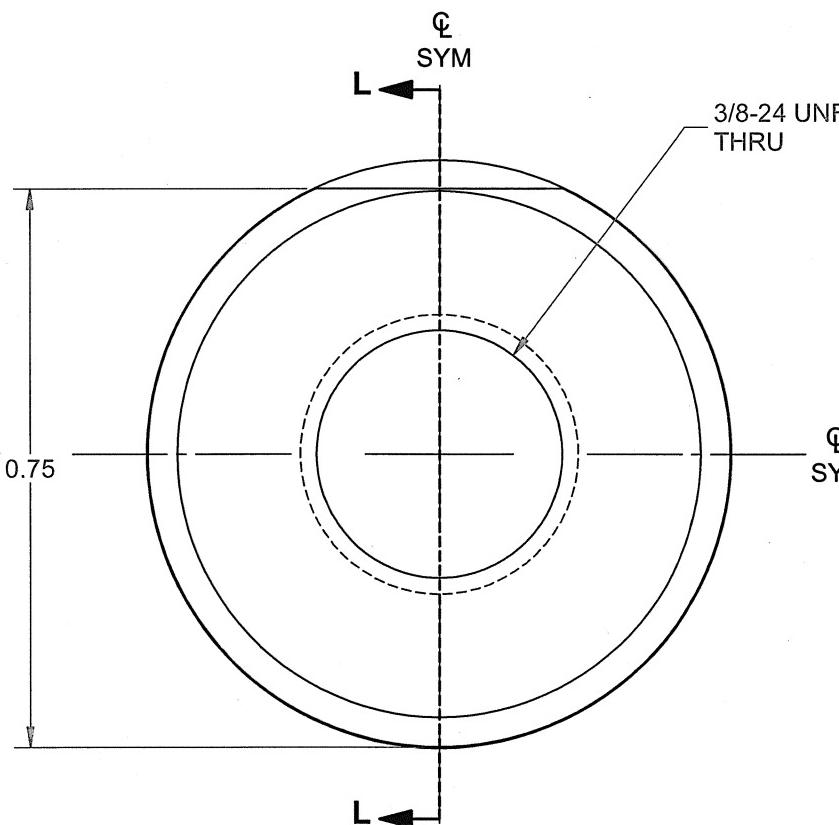
3

2

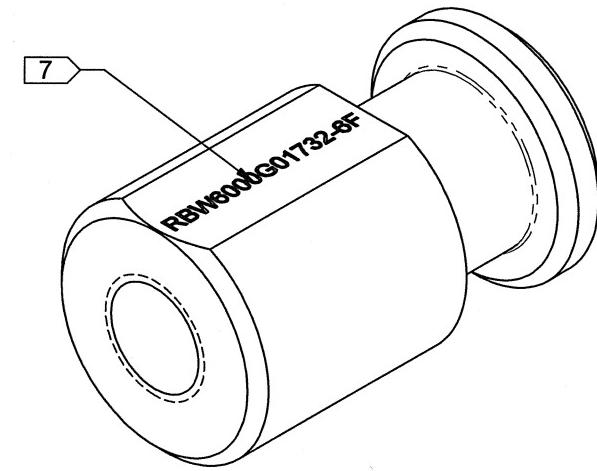
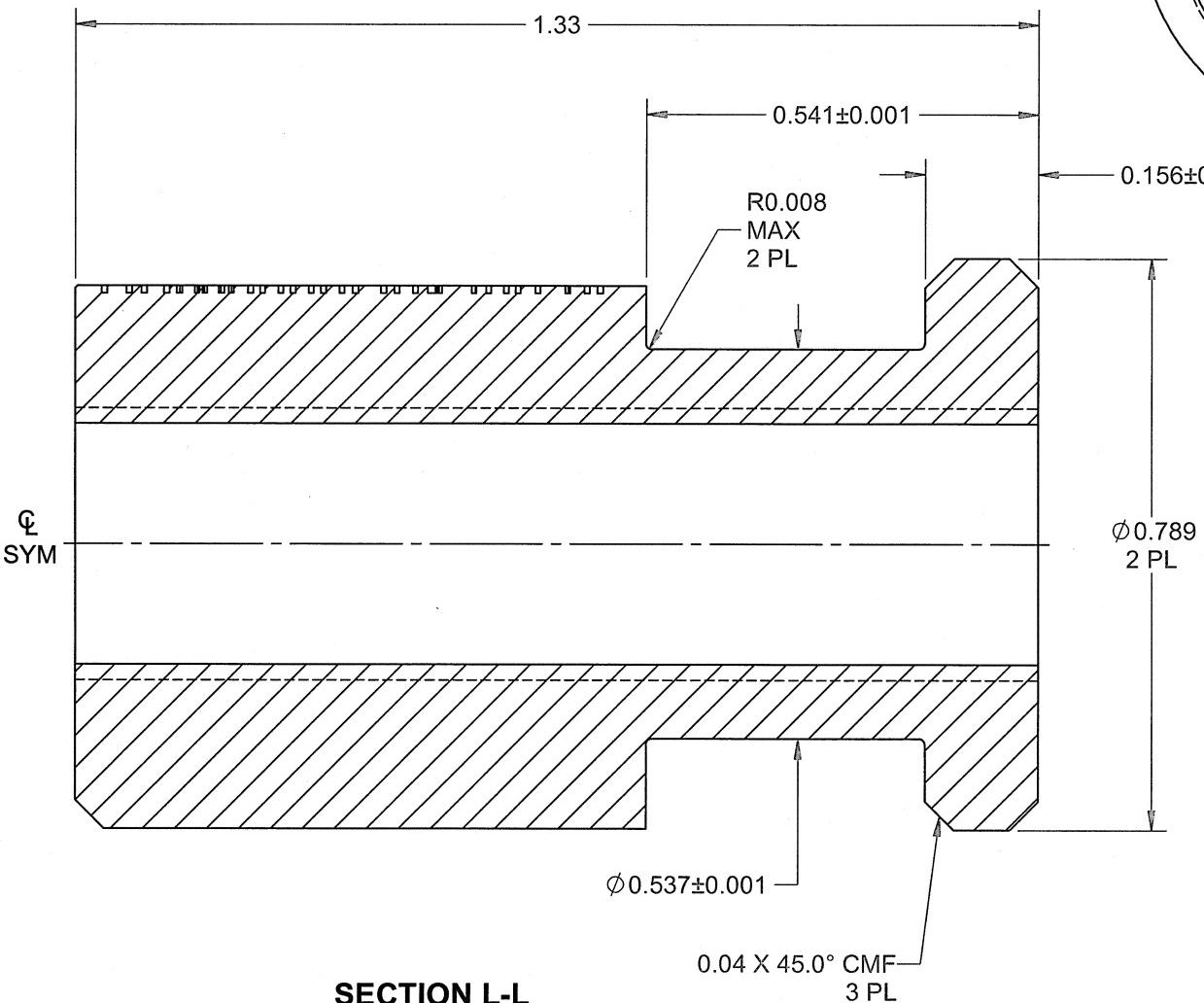
1

D

D



RBW6000G01732-6F-16 SPACER



NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 - X.XX = +/- 0.01" / +/- 0.5°
 - X.XXX = +/- 0.005" / +/- 0.1°
 - X.XXXX = +/- 0.0005" / +/- 0.05°
- PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RBW6000G01732-6F", AS SHOWN

DESIGN	VM	DART AEROSPACE LTD
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	FK	RBW6000G01732-6F
APPROVED	<i>WP</i>	REV. A
DATE 2019-08-16		SHEET 18 OF 19
TITLE AXIAL PLAY CHECK TOOL		SCALE NTS
COPRIGHT © 2019 BY DART AEROSPACE LTD		
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		

8

7

6

5

4

3

2

1

D

D

C

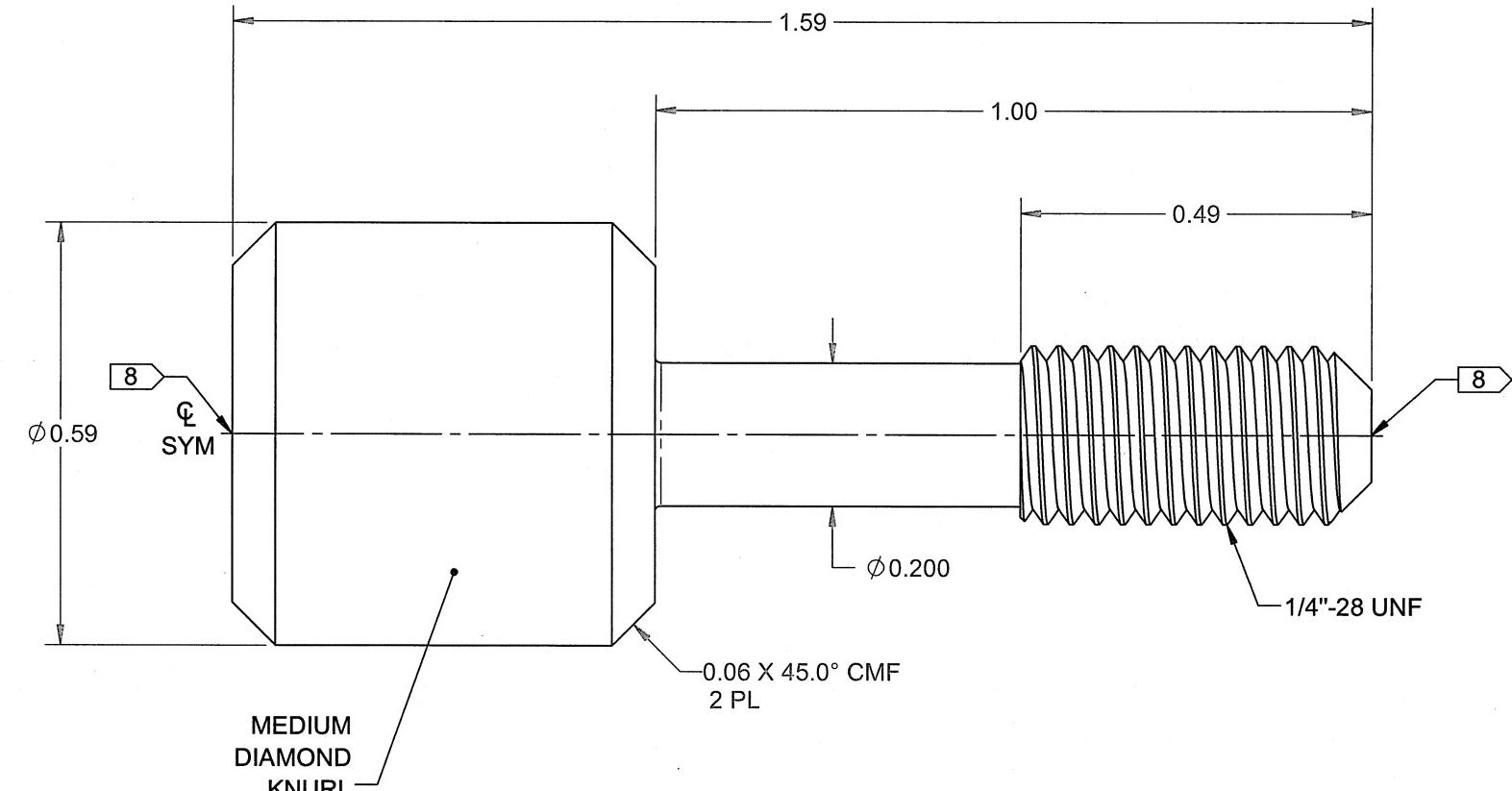
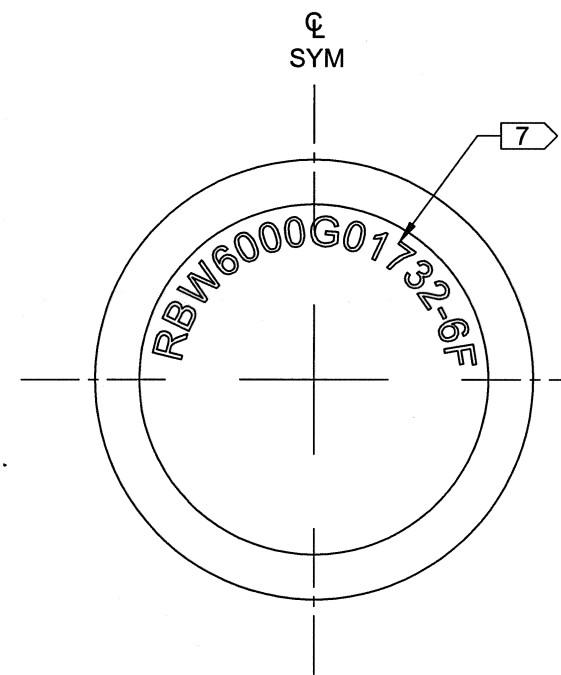
C

B

B

A

A



RBW6000G01732-6F-17 HOLE PIN

NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RBW6000G01732-6F", AS SHOWN
- 8) CENTER DRILL IS ACCEPTABLE

DESIGN	VM	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	KPT		
MFG. APPR.	FK		
APPROVED	VJ		
DATE 2019-08-16		REV. A	
TOOL PART # RBW6000G01732-6F		SHEET 19 OF 19	
TITLE AXIAL PLAY CHECK TOOL		SCALE NTS	

COPYRIGHT © 2019 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE LTD.